

Work Order ID 98331-2

March-12-13 1:47:23 PM

\*98331\*

Page 1

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 3/11/13 Start Qty: 12.00

Required Date: 3/22/13 Req'd Qty: 12.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS

QC:

Date: 3-03-14 Tooling:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

\*100\*

Waterjet

FLOW CNC Waterjet

304-005

FLOW WATERJET

0.00

Memo

0.00

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-11) \*\*\*\*\* Dwg Rev: 0 Prog.  
Rev: 0 2-Debur if necessary

13 0

Jm13-3-21

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

13 0

Jm13-3-21

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

D3564-11

13 0 01

13 0

# Work Order ID 98331

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Page 2

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 3/11/13 Start Qty: 12.00

Required Date: 3/22/13 Req'd Qty: 12.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

\*130\*

Brake NC

Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs D18179

12

13/03/20

140

\*140\*

QC

Quality Control

QC'S- Inspect part completeness to step on W/O

0.00

Memo

0.00

13-3-J

12

150

\*150\*

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat  
M124842 Weld hardcoat as per Dwg D3437

4

13-03-26  
JOL

# Work Order ID 98331

March-12-13 1:47:23 PM

\*98331\*

Page 3

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 3/11/13

Start Qty: 12.00

Required Date: 3/22/13

Req'd Qty: 12.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

\*160\*

QC

Quality Control

Memo

0.00

(4)

13-03-27

DAS  
09  
2-83

170

QC5- Inspect part completeness to step on W/O

0.00

\*170\*

QC

Quality Control

Memo

0.00

(4)

13-03-27

DAS  
09  
2-83

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*180\*

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

7:30

0.00

3200F

8:00

4X M-F 13/03/27

m122966

# Work Order ID 98331

March-12-13 1:47:23 PM

\*98331\*

Page 4

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 3/11/13

Start Qty: 12.00

Required Date: 3/22/13

Req'd Qty: 12.00

Reference:

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00

\*190\*

QC

Quality Control

Memo

0.00

4 x d Jell 13/03/12

200

Identify as per dwg & Stock Location: 1-P-000 0.00

\*200\*

Packaging

Memo

0.00

Packaging

4 x d Jell 13/03/12

210

QC21- Final Inspection - Work Order Release 0.00

\*210\*

QC

Quality Control

Memo

0.00

13/3/28 JF

WUF  
B3-27



# Picklist Print

March-12-13 1:47:23 PM

Work Order ID: 98331  
Parent Item: D3564-11  
Parent Item Name: Wearshoe

Start Date: 3/11/13

Required Date: 3/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B As per Rev C 07-07-09 JLM  
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	567.8630	1.41	17.810526 18			

JMB-3-2

Location

Loc Qty

Loc Code

MAT020

567.863

122245

5.156

123136

140.8

124428

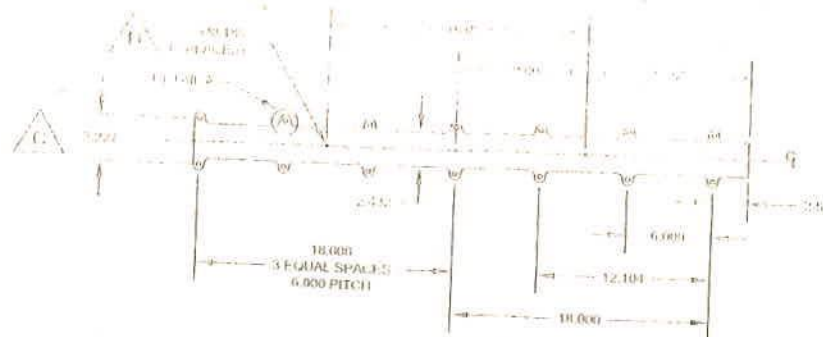
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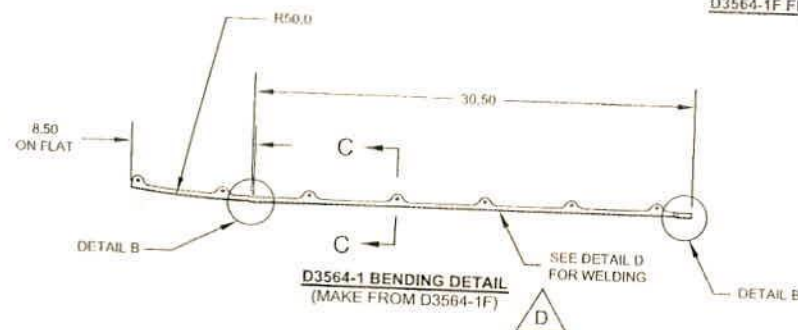
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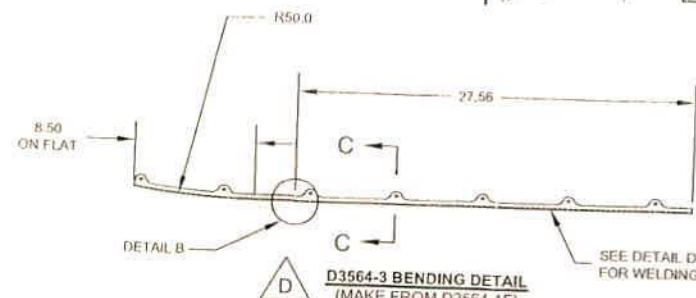




D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

UNDER REVIEW

OK 11/11/25

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1; PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
	C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
	B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
	A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH			
DRAWN	CB			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	07.08.21			

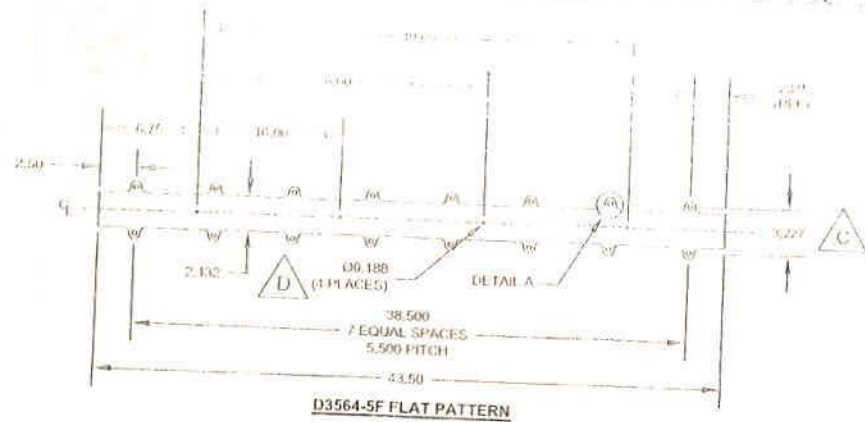
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564  
REV. D  
SHEET 1 OF 3  
TITLE WEARSHOE  
SCALE 1:8

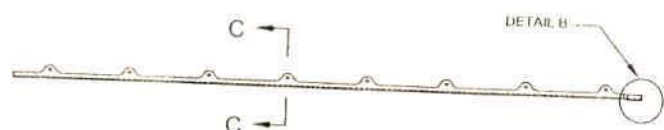
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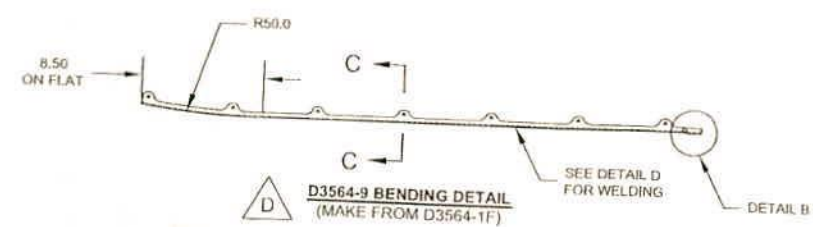
98331



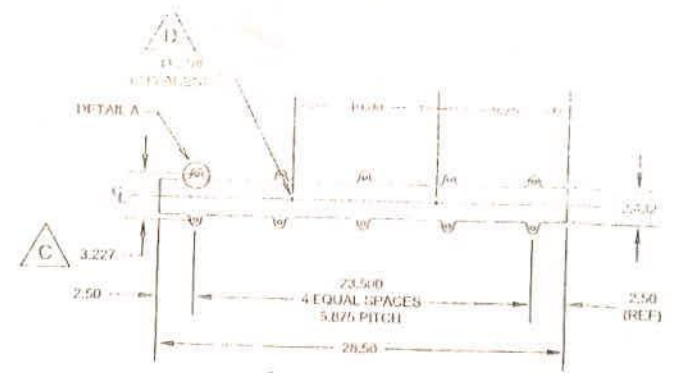
**D3564-5F FLAT PATTERN**



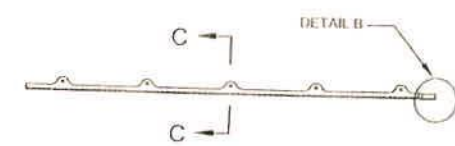
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



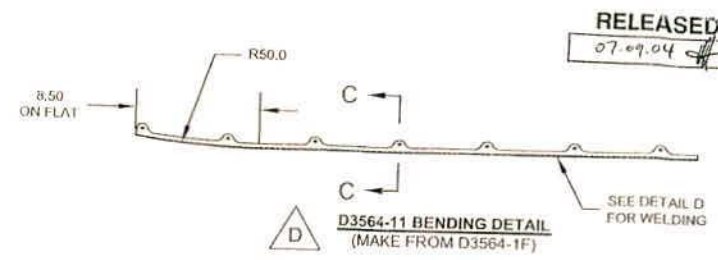
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

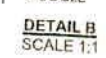
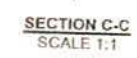
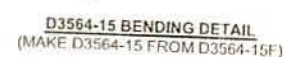
UNDER REVIEW  
OK 07.11.25

RELEASED  
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	



LETTER FROM...



DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D3564  TITLE WEARSHOE  COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ORIGINALLY INTENDED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>	REV. D
DRAWN	CB		SHEETS 3 OF 3
CHECKED	PH		SCALE
MFG. APPR.	PH		1:8
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		